

Date: Thursday, 6/22/2006 8:41:58 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET (A119) ARMS
Job Number : 27660	
Estimate Number : 12437	
P.O. Number :	Part Number : D35181
This Issue : 6/22/2006 S.O. No. : NIA	Drawing Number : D3518 PRELIMINARY
Prsht Rev. : NC	Project Number : N/A
First Issue : NIA Type : R & D SM/MED FAB	Drawing Revision : A PRELIMINARY
Previous Run : NIA	Material : NIA
Written By : <u>SPR COMMENT BELOW</u>	Due Date : 6/23/2006 Qty: 2 Um: Each
Checked & Approved By : <u>W</u>	
Comment : EST rev. A 05.06.06 preliminary EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M6061T6B0875X06000	6061-T6 Bar 875" x 6.0"
-----	--------------------	-------------------------



Comment: Qty.: 0.1400 f(s)/Unit Total : 0.2799 f(s)
 6061-T6 Plate .875" x 6.0"
 (M6061T6B0875X06000)
 Batch: 1161323

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

**Comment:** FLOW WATER JET

1-Cut as per Dwg D3518

Dwg Rev: PreliminaryProg Rev: Preliminary

2-Open holes to finish size as per Dwg D3518

3-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------

**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Date: Thursday, 6/22/2006 8:41:58 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET (A119) ARMS

Job Number: 27660

Part Number: D35181

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06/07/17 SAE

8.0

PACKAGING 1

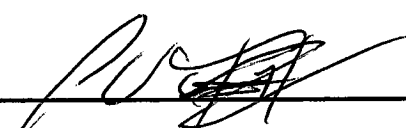
PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 



9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.18

Job Completion

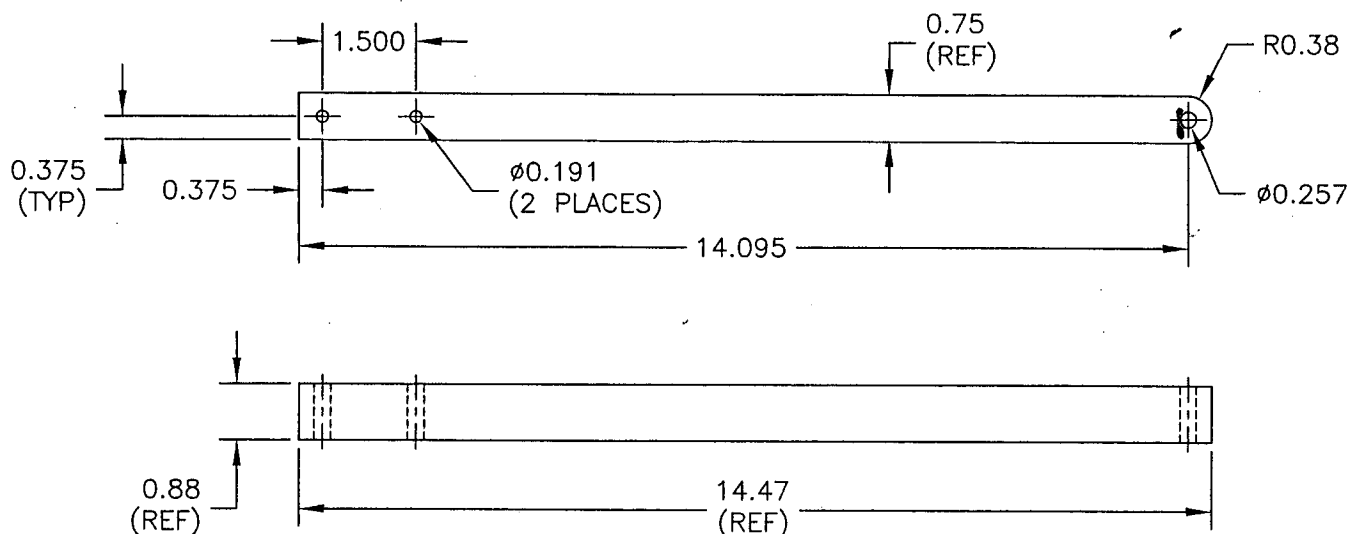


06.07.17

PRELIMINARY ISSUE

06.06.22

DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3518	REV. B SHEET 2 OF 2
DATE 06.06.21		TITLE BASKET (A119) STRUT	SCALE 1:3



2x

D3518-1 STRUT

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
06-06-22

NOTES:




- 1) MATERIAL: M6061-T6 (OR 6061-T62) ALUMINUM BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF DART MATERIAL SPEC M6061T6B)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX

Copyright © 2006 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

☒ First Article ☒ Prototype

[illegible]

Measured by:		Audited by:		Prototype Approval:	
Date:	06.06.22	Date:	06.06.22	Date:	06.06.22

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	